



(11) **EP 2 801 657 A1**

(12) **EUROPEAN PATENT APPLICATION**
published in accordance with Art. 153(4) EPC

(43) Date of publication:
12.11.2014 Bulletin 2014/46

(51) Int Cl.:
D06M 11/71 (2006.01) D06M 11/00 (2006.01)

(21) Application number: **12864292.3**

(86) International application number:
PCT/KR2012/010461

(22) Date of filing: **05.12.2012**

(87) International publication number:
WO 2013/103199 (11.07.2013 Gazette 2013/28)

(84) Designated Contracting States:
**AL AT BE BG CH CY CZ DE DK EE ES FI FR GB
GR HR HU IE IS IT LI LT LU LV MC MK MT NL NO
PL PT RO RS SE SI SK SM TR**

(30) Priority: **05.01.2012 KR 20120001338**

(71) Applicant: **LG Hausys, Ltd.**
Seoul 150-721 (KR)

(72) Inventors:
• **LEE, Ju-Hyung**
Uiwang-si
Gyeonggi-do 437-761 (KR)
• **JUNG, Seong-Moon**
Daejeon 305-707 (KR)

- **LEE, Myung**
Hwaseong-si
Gyeonggi-do 445-761 (KR)
- **KIM, Eun-Joo**
Anyang-si
Gyeonggi-do 431-080 (KR)
- **KIM, Hyun-Jae**
Seoul 151-775 (KR)

(74) Representative: **Alber, Norbert**
Hansmann & Vogeser
Patent- und Rechtsanwälte
Albert-Roßhaupter-Straße 65
81369 München (DE)

(54) **GLASS FIBER BOARD COMPRISING INORGANIC BINDER AND METHOD FOR PREPARING SAME**

(57) The present invention provides a glass fiber board comprising a glass fiber and an inorganic binder, wherein the inorganic binder comprises an aluminum phosphate.

The present invention provides a method for preparing the glass fiber board comprising (a) preparing an in-

organic binder solution comprising an aluminum phosphate (b) applying the inorganic binder solution comprising the aluminum phosphate to a glass fiber; (c) compressing the glass fiber to which the inorganic binder solution comprising the aluminum phosphate is applied; and (d) drying the compressed glass fiber.

EP 2 801 657 A1

Description

[Technical Field]

5 **[0001]** The present invention relates to a glass fiber board comprising an inorganic binder, and more particularly, a method for preparing a glass fiber board that may maintain optimal thermal conductivity values with a small amount of inorganic binders, and show high compression and high strength.

[Background Art]

10 **[0002]** When manufacturing vacuum heat insulation materials, development of a core member for the vacuum heat insulation materials having thermal conductivity performance and having threshold densities and strengths for convenience of the manufacturing process of the vacuum heat insulation materials was also required.

15 **[0003]** Especially, when manufacturing the core member for the vacuum heat insulation materials, especially since a glass fiber wool cannot but have a high volume from a fiber manufacturing process, density is very low. And thus, when manufacturing the core member for the vacuum heat insulation materials, thermo compression methods were generally used to manufacture boards. Here, since the thermo compression methods indicate methods for adhering glass fiber with each other by applying heat of up to glass deflection temperatures (about 500°C) of a glass fiber wool, the thermo compression methods have problems of having high energy costs and maintenance costs. Korea publication No.
20 10-2004-0086165 also discloses a method for applying binders to glass fibers, but it comprises a molded product formed from thermo compression or a core member of vacuum heat insulation materials laminating 2 or more layers of the molded product, thus disclosing only about a thermo press method similar to a thermo compression method and does not solve problems of the thermo compression methods.

25 [Disclosure]

[Technical Problem]

30 **[0004]** To improve the problems described above, an objective of the present invention is to attempt and apply compression of glass fibers using an inorganic fiber. And more particularly, a method for preparing a glass fiber board maintaining optimal thermal conductivity values with a small amount of inorganic binders and showing high compression and high strength is provided.

[Technical Solution]

35 **[0005]** To achieve the objective described above, the present invention provides a glass fiber board comprising a glass fiber and an inorganic binder, wherein the inorganic binder comprises an aluminum phosphate.

40 **[0006]** To achieve another objective described above, the present invention provides a method for preparing the glass fiber board comprising (a) preparing an inorganic binder solution comprising an aluminum phosphate (b) applying the inorganic binder solution comprising the aluminum phosphate to a glass fiber; (c) compressing the glass fiber to which the inorganic binder solution comprising the aluminum phosphate is applied; and (d) drying the compressed glass fiber.

[Advantageous Effects]

45 **[0007]** The present invention, by comprising an aluminum phosphate inorganic binder solution, a glass fiber board maintains optimal thermal conductivity values with a small amount, and shows high compression and high strength. Also, by reducing energy costs and maintenance costs applying a method for preparing the glass fiber board in accordance with the present invention, production efficiency of glass fiber boards may be increased.

50 [Best Mode]

55 **[0008]** Advantages and features of the present invention, and method for achieving thereof will be apparent with reference to the examples that follow. But, it should be understood that the present invention is not limited to the following examples and may be embodied in different ways, and that the examples are given to provide complete disclosure of the invention and to provide thorough understanding of the invention to those skilled in the art, and the scope of the invention is limited only by the accompanying claims and equivalents thereof. Like components will be denoted by like reference numerals throughout the specification.

[0009] Hereinafter, the present invention will be described in detail.

Glass fiber board

[0010] The present invention provides a glass fiber board comprising a glass fiber and an inorganic binder. The glass fiber comprised in the present invention, may use all of the materials without limitation if used for core materials of vacuum heat insulation materials, but especially, using a standardized glass fiber without air pollution and easily prepared is preferable. For this glass fiber, a glass wool, a ceramic fiber, a rock wool, a glass fiber, an alumina fiber, a silica alumina fiber, a silica fiber, a silicon carbide fiber, etc. may be used. Here, the glass fiber wool may use a glass wool fabric by cutting in a shape of a square, circle, etc. in accordance with a shape of the vacuum heat insulation material.

[0011] It is preferable for the glass fiber to have a mean diameter of 4 to 6 μ m. When the mean diameter of the glass fiber is less than 4 μ m, it falls into a category of a micro fiber and manufacturing costs become very high and may be hazardous to the human body, and when exceeding 6 μ m, the number of contact surfaces of the glass fiber itself increase and an initial thermal conductivity may become high. Therefore, a mean diameter of less than 6 μ m for the glass fiber is appropriate in aspects of efficiency of preparing the core member for the vacuum heat insulation material comprising an inorganic binder together.

[0012] The glass fiber board of the present invention uses an inorganic binder instead of an organic binder, which is impossible to use because degrees of vacuum decrease due to the organic matter volatilizing in a vacuum state, and since strength and compression ratio become excellent when the amount of the inorganic binder comprised in the core member for the vacuum heat insulation material increases, an appropriate density with optimal thermal conductivity may be attained.

[0013] The glass fiber board is comprised of materials able to secure excellent long-term durability, and may be used in product forms of a glass fiber board, a sheet, or a paper. Additionally, for materials to improve long-term durability, a fumed silica powder, a silica powder, a pearlite powder, and an aerogel powder may be used, and may be composed by comprising one or more among these.

[0014] The glass fiber board described in the present invention comprises a glass fiber and an inorganic binder, and the inorganic binder comprises an aluminum phosphate. Here, the aluminum phosphate is formed as an aluminum precursor and a phosphorus precursor. The aluminum precursor is selected from the group consisting of aluminum hydroxide, aluminum nitrate, aluminum acetate, or aluminum halide, and the phosphorus precursor is selected from the group consisting of phosphate (H_3PO_4), monoammonium phosphate ($NH_4H_2PO_4$), diammonium phosphate ($(NH_4)_2HPO_4$), triethyl phosphine ($(C_2H_5)_3P$), or trimethyl phosphine ($(CH_3)_3P$).

[0015] Also, by maintaining the particle size of the aluminum precursor in a particle size smaller than prior commercial sol shaped silica and alumina particle shaped inorganic binders, effects of precise binding may be made from polymerization of phosphoric acid.

[0016] Therefore, by comprising the precursor with a particle size of 10nm or less, different from prior aluminum precursors with a particle size of 20 to 50nm, it may have advantages of attaching to the glass fiber more uniformly. In the case of inorganic binders prepared from the aluminum precursor with prior particle sizes, there are problems of ununiform dispersion of binders from sloshing effects of binders during drying.

[0017] The aluminum phosphate formed as the aluminum precursor and the phosphorus precursor composing the inorganic binder of the present invention has, preferably, an atomic ratio of P/Al to be 3 ~50, and here, the atomic ratio of P/Al indicates a molar ratio of phosphorus and aluminum.

[0018] When the atomic ratio of P/Al of the aluminum phosphate is less than 3, solubility of alumina is very low and there are concerns of formation of the aluminum phosphate not being smooth, and when the atomic ratio of P/Al of the aluminum phosphate is more than 50, phosphorous is in excess, and thus strength may be weakened because the surface of the glass fibers are damaged and may show properties of continuously absorbing moisture.

[0019] The inorganic binder comprising the aluminum phosphate comprises 0.05 to 10 parts by weight based on 100 parts by weight of the glass fibers. The glass fiber board of the present invention, even though comprising a small amount of the aluminum phosphate inorganic binder, may maintain optimal thermal conductivity values, and thus high strength and highly compressed glass fiber boards may be prepared. When the inorganic binder comprising the aluminum phosphate is less than 0.05 parts by weight based on 100 parts by weight of the glass fibers, there are concerns of the functions of the binder weakening, and when exceeding 10 parts by weight, there are problems in that thermal conductivity becomes high due to increase in density.

[0020] The glass fiber board may be a glass fiber board for the core member of the vacuum heat insulation materials. The glass fiber board is a heat insulation material with heat insulating effects, workability, fire resistance, etc., and the glass fiber board may comprise the inorganic binder comprising the glass fibers and the aluminum phosphate, and by being used for the core member of the vacuum heat insulation materials, the core member of the vacuum heat insulation material with excellent initial heat insulation performance and securing long term durability and the vacuum heat insulation material comprising the core member of the vacuum heat insulation material may be provided.

Method form preparing a glass fiber board

[0021] A method for preparing the glass fiber board in accordance with the present comprises applying an inorganic binder, compressing, and drying.

[0022] More particularly, the present invention comprises a method for preparing a glass fiber board comprising the steps of: (a) preparing an inorganic binder solution comprising an aluminum phosphate; (b) applying the inorganic binder solution comprising the aluminum phosphate to a glass fiber; (c) compressing the glass fiber to which the inorganic binder solution comprising the aluminum phosphate is applied; and (d) drying the compressed glass fiber.

[0023] In the step (a), an inorganic binder comprising an aluminum phosphate is prepared from reaction of an aluminum precursor and a phosphorus precursor. Here, the aluminum precursor may be selected from the group consisting of aluminum hydroxide, aluminum nitrate, aluminum acetate, or aluminum halide, and the phosphorus precursor may be selected from the group consisting of orthophosphate (H_3PO_4), monoammonium phosphate ($\text{NH}_4\text{H}_2\text{PO}_4$), diammonium phosphate ($(\text{NH}_4)_2\text{HPO}_4$), triethyl phosphine ($(\text{C}_2\text{H}_5)_3\text{P}$), or trimethyl phosphine ($(\text{CH}_3)_3\text{P}$).

[0024] It is preferable to use aluminum hydroxide for the aluminum precursor and phosphate for the phosphorus precursor, and since solubility is low when using the aluminum hydroxide for the aluminum precursor, heat-treat at 150°C or over may be comprised. In the heat-treat step comprised in the preparing an inorganic binder solution step comprising the aluminum phosphate of the present invention, since a heat-treat of 150°C or over is required, aluminum nitrate or aluminum acetate with high solubility in room temperatures and thus may melt in room temperatures may be further comprised. Here, since there are dangers of a nitric acid gas generating in the case of the aluminum nitrate, using the aluminum acetate is more preferable.

[0025] More specifically, in a reaction mechanism of the inorganic binder solution comprising the aluminum phosphate, phosphoric acid ions and aluminum ions, acetate are dissolved in a solution in room temperatures, and oligo-phosphate or poly-phosphate is formed by a polymerization of phosphate at 150°C or over in the heat-treat process after coating, and may take the role of the binder by forming compounds such as $\text{Al}(\text{H}_2\text{PO}_4)_3$, $\text{AlH}_2\text{P}_3\text{O}_{10}$, $\text{Al}(\text{PO}_3)_3$, $\text{Al}_2\text{P}_6\text{O}_{18}$, etc. in accordance with changes in temperatures.

[0026] In the step (b), when applying the inorganic binder solution on the glass fiber, generally, it is preferable to use a spray method. Generally, the glass fibers exist in a glass fiber wool state, and applying the inorganic binder solution on the glass fiber wool is also possible, but here, for a uniform binder coating, it is preferable to apply the inorganic binder of the present invention in a glass fiber state before the glass fiber wool is formed. This is because, compared to when the glass fibers exist in the glass fiber wool state, it is difficult for the inorganic binders to penetrate inside because volume increases, and a large amount of solvents are needed for a uniform inorganic binder penetration, and in comparison, when applying the inorganic binder solution directly to the glass fibers, the penetration of the binders inside the glass fibers is possible even when using a small amount of solvents.

[0027] Especially, when using the inorganic binder comprising the aluminum phosphate, even when adding a small amount using a spray method on a surface of the glass fiber, target strength may be secured, and as a result, thermal conductivity values rising may be prevented beforehand. Here, it is important for the binder to be coated as uniformly as possible on the surface of the glass fiber. In this case, a variety of methods may be attempted according to needs of the preparing process, and when applying the inorganic binders on the glass fiber wool, an excess amount of solvents are required for a uniform binding. Therefore, as described above, applying the inorganic binder when the glass fiber is injected right before the glass fiber wool is formed is convenient in that it may use small amounts of solvents.

[0028] In step (c), it is preferable for a compression pressure to be 2.0 to 2.4Kg/cm^2 when compressing the glass fiber. A compression roll, a compression press, etc. may be used for the compression. When the compression pressure is less than 2.0Kg/cm^2 , there are concerns of insufficient compression, and when exceeding 2.4Kg/cm^2 , there are problems of glass fiber breaking.

[0029] Also, in the method for preparing a glass fiber board, a drying temperature in the step (d) is preferably 200 to 400°C and a drying time is preferably performed for 10 to 20 minutes. When the drying temperature is below 200°C , there are concerns that polyphosphate is not sufficiently generated, and when over 400°C , there are problems of high energy costs. Also, when the drying time is less than 10 minutes, there are concerns of insufficient drying, and when exceeding 20 minutes, there are problems of inefficiencies of the production process.

[0030] Hereinafter, it is further described in detail through the following examples of the present invention. But the following examples are for illustration of the contents of the invention only, and the scope of the present invention is not limited to the examples.

Examples

[0031] Hereinafter, configurations and effects of the present invention are described in further detail from the following preferred examples. But, the following examples are provided as preferred examples of the present invention and the scope of the present invention is not limited to these.

[0032] Contents not presented here may be inferred by those skilled in the arts and its descriptions are skipped.

<Example 1>

1. Manufacturing an aluminum phosphate inorganic binder

[0033] While stirring 309.5g of distilled water at 230rpm, 1,150g, 85% of phosphate was added in a span of 5 minutes. While stirring the diluted phosphate at 500 rpm, 94.5kg of aluminium acetate powder was added in a span of 6 minutes and then stirred for 20 minutes, and an aluminum phosphate inorganic binder with an atomic ratio of P/Al of 20 was prepared.

2. Manufacturing a glass fiber and a core member for a vacuum heat insulation material

[0034] A glass fiber having a mean diameter of 4 μ m, mass of 50g was prepared. Also, 2g of the manufactured aluminum phosphate inorganic binder was put into 200g of water and stirred to prepare an inorganic binder solution comprising the aluminum phosphate. Here, the inorganic binder solution was applied on the glass fiber, and after compressing at a pressure of 2.0kg/cm², it was dried for 20 minutes at 200°C, and cut to a size of 193x253x2mm (thicknessxwidthxlength) to prepare the glass fiber board. Here, a core member for a vacuum heat insulation material was manufactured with 1 piece of the glass fiber board.

<Example 2>

1. Manufacturing an aluminum phosphate inorganic binder

[0035] While stirring 309.5g of distilled water at 230rpm, 1,150g, 85% of phosphate was added in a span of 5 minutes. While stirring the diluted phosphate at 500 rpm, 94.5kg of aluminium acetate powder was added in a span of 6 minutes and then stirred for 20 minutes, and an aluminum phosphate inorganic binder with an atomic ratio of P/Al of 20 was prepared.

2. Manufacturing a glass fiber and a core member for a vacuum heat insulation material

[0036] A glass fiber with a mean diameter of 4 μ m, mass of 100g was prepared. Also, 1g of the manufactured aluminum phosphate inorganic binder was put into 200g of water and stirred to prepare an inorganic binder solution comprising the aluminum phosphate. Here, the inorganic binder solution was applied on the glass fiber, and after compressing at a pressure of 2.4kg/cm², it was dried for 10 minutes at 400°C, and cut to a size of 193x253x2mm (thicknessxwidthxlength) to prepare the glass fiber board. Here, a core member for a vacuum heat insulation material was prepared by laminating 2 pieces of the glass fiber board.

<Comparative example 1>

[0037] A glass fiber wool of 190x250x50mm (thicknessxwidthxlength), a mean diameter of 6 μ m, and a mass of 50g was prepared. Here, a core member for a vacuum heat insulation material was manufactured by using a thermo compression method forming the glass fiber wool at 500°C.

<Comparative example 2>

[0038] A core member for a vacuum heat insulation material was manufactured by using a wet process using an organic binder for the glass fiber wool same as the Comparative example 1.

<Experimental example> Measuring thermal conductivity of a vacuum heat insulation material

[0039] The core members for the vacuum heat insulation material according to the Examples 1 and 2, and Comparative examples 1 and 2 were manufactured in a size of 25x300x400mm (thicknessxwidthxlength). Next, an outer sealing member formed in a structure of 12 μ m of a polyvinylidene chloride (PVDC)/ polyethylene terephthalate film (PET), 25 μ m of a nylon film, 6 μ m of an Al foil, and 50 μ m of a linear low density polyethylene (LLDPE) film was formed. And then, 2g of a getter, which was manufactured by adding 25g of 95% purity quicklime in a pouch, was inserted in the surface of the prepared core member.

[0040] And then, after inserting the core member in a sealing member, it was sealed in a vacuum state of 10Pa and

the vacuum heat insulation material in accordance with the present invention was manufactured.

[0041] The vacuum heat insulation material according to the described Examples 1 and 2, and Comparative examples 1 and 2 were aging treated at 70°C for 14 hours, and then put in a constant temperature chamber of 85°C and while maintaining for 10 days, thermal conductivity was measured. Here, HC-074•300 (manufactured by EKO Instruments) thermal measurement device was used to measure the thermal conductivity, and the results are as in Table 1.

[Table 1]

	Example 1	Example 2	Comparative example 1	Comparative example 2
Thermal conductivity value (mW/mK)	2.579	2.526	3.058	3.323

[0042] As can be seen by referring to the Table 1, the thermal conductivity of Comparative examples 1 and 2 being higher than the thermal conductivity of Examples 1 and 2 was observed.

[0043] More specifically, the thermo compression method used in the Comparative example 1 is a method adhering the glass fibers with each other by applying heat up to a strain temperature (500 ° C) of the glass fiber wool, and not only is the thermal conductivity in the case of Examples 1 and 2, which applies compression of the glass fiber wool using binders, low, but also has excellent effects in aspects of energy and maintenance costs.

[0044] Also, in the case of Comparative example 2, which applies compression of the glass fiber wool using the inorganic binders, the thermal conductivity being larger than in the case of Examples 1 and 2, which applies compression of the glass fiber wool using the binders, was identified, and it was identified that an optimal thermal conductivity was maintained in the case of the vacuum heat insulation material applying the glass fiber of the present invention.

<Experimental example> Measuring a flexural strength of a core member for a vacuum heat insulation material and an absorption ratio of water

[0045] A flexural strength and an absorption ratio of water from physical properties of the core member for the vacuum heat insulation material according to the Examples 1 and 2 and Comparative examples 1 and 2 were measured, and its result is as the following Table 2.

[0046] Since the flexural strength indicates resistance strength with respect to folding and bending, the flexural strength was compared by folding and bending the vacuum heat insulation material repetitively and measuring the number of times before being severed.

[Table 1]

	Example 1	Example 2	Comparative example 1	Comparative example 2
flexural strength (Mpa)	15	17	13	11

[0047] Referring to Table 2, in the case of Examples 1 and 2, which comprises an aluminum phosphate inorganic binder, shows a slightly more excellent flexural strength compared to Comparative example 1, which does not comprise binders, and Comparative example 2, which comprises an organic binder, and even though it is not written in the experimental result, absorption ratio of water being also slight lower in the case of Examples 1 and 2 was identified.

[0048] Therefore, the glass fiber board in accordance with the present invention, by adding the aluminum phosphate inorganic binder with the glass fiber, secured excellent strength, and the objective of obtaining a high strength glass fiber board by compressing the glass fiber with small amounts of inorganic binders was achieved.

Claims

1. A glass fiber board comprising a glass fiber and an inorganic binder, wherein the inorganic binder comprises an aluminum phosphate inorganic binder.
2. A glass fiber board according to claim 1, wherein the aluminum phosphate is formed with an aluminum precursor and a phosphorus precursor.
3. A glass fiber board according to claim 2, wherein the aluminum precursor is selected from the group consisting of aluminum hydroxide, aluminum nitrate, aluminum acetate, or aluminum halide, and the phosphorus precursor is

selected from the group consisting of phosphate (H_3PO_4), monoammonium phosphate ($\text{NH}_4\text{H}_2\text{PO}_4$), diammonium phosphate ($(\text{NH}_4)_2\text{HPO}_4$), or triethyl phosphine ($(\text{C}_2\text{H}_5)_3\text{P}$), trimethyl phosphine ($(\text{CH}_3)_3\text{P}$).

4. A glass fiber board according to claim 2, wherein a particle size of the aluminum precursor is 2 to 10nm.
5. A glass fiber board according to claim 1, wherein an atomic ratio of P/Al of the aluminum phosphate is 3 to 50.
6. A glass fiber board according to claim 1, wherein an inorganic binder comprising the aluminum phosphate comprises 0.05 to 10 parts by weight, based on 100 parts by weight of the glass fiber.
7. A glass fiber board according to claim 1, wherein a mean diameter of the glass fiber is 4 to 6 μm .
8. A method for preparing a glass fiber board comprising the steps of:
 - (a) preparing an inorganic binder solution comprising an aluminum phosphate;
 - (b) applying the inorganic binder solution comprising the aluminum phosphate to a glass fiber;
 - (c) compressing the glass fiber to which the inorganic binder solution comprising the aluminum phosphate is applied;
 - (d) drying the compressed glass fiber.
9. A method for preparing a glass fiber board according to claim 8, wherein the inorganic binder solution comprising an aluminum phosphate in the step (a) is prepared with an aluminum precursor and a phosphorus precursor.
10. A method for preparing a glass fiber board according to claim 8, wherein the step (a) comprises a step to heat-treat at temperatures of 150°C or over.
11. A method for preparing a glass fiber board according to claim 10, wherein the heat-treat step further comprises an aluminum nitrate or an aluminum acetate.
12. A method for preparing a glass fiber board according to claim 8, wherein the compressing in step (c) is performed with a pressure of 2.0 to 2.4Kg/cm².
13. A method for preparing a glass fiber board according to claim 8, wherein the drying in step (d) is performed for 10 to 20 minutes at temperatures of 200 to 400°C.
14. A glass fiber board according to claim 1, wherein the glass fiber board is a glass fiber board for a core member of a vacuum heat insulation material.

INTERNATIONAL SEARCH REPORT

International application No.

PCT/KR2012/010461

A. CLASSIFICATION OF SUBJECT MATTER

D06M 11/71(2006.01)i, D06M 11/00(2006.01)i

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

D06M 11/71; D04H 1/42; C04B 35/76; D04H 1/64; C08J 5/14; C04B 35/80; B01J 23/40; B01D 53/72; F23M 5/00; B29B 11/16

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Korean Utility models and applications for Utility models: IPC as above

Japanese Utility models and applications for Utility models: IPC as above

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

eKOMPASS (KIPO internal) & Keywords: inorganic fiber, glass fiber, insulating material, inorganic binder, aluminum phosphate, aluminum precursor, phosphorus precursor, compression, dry, heat treatment, core for vacuum insulating material

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
Y A	JP 2003-113565 A (NIPPON GLASS FIBER KOGYO KK) 18 April 2003 See the claims, paragraphs [0024]-[0029].	1-9,14 10-13
Y A	WO 91-02705 A1 (ALUMINUM COMPANY OF AMERICA) 07 March 1991 See abstract, pages 13-14 example 1, the claims.	1-9,14 10-13
A	JP 2009-046374 A (FUSO KOGYO KK) 05 March 2009 See abstract, the claims, paragraph [0016].	1-14
A	JP 11-335183 A (NICHIAS CORP) 07 December 1999 See abstract, the claims.	1-14
A	JP 05-331297 A (HITACHI CHEM CO., LTD.) 14 December 1993 See abstract, the claims, paragraphs [0007][0010][0014].	1-14
A	KR 10-1996-0003793 B1 (YUKONG LTD) 22 March 1996 See example 1, the claims.	1-14

☐ Further documents are listed in the continuation of Box C.☒ See patent family annex.

* Special categories of cited documents:

"A" document defining the general state of the art which is not considered to be of particular relevance

"E" earlier application or patent but published on or after the international filing date

"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)

"O" document referring to an oral disclosure, use, exhibition or other means

"P" document published prior to the international filing date but later than the priority date claimed

"I" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention

"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone

"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art

"&" document member of the same patent family


Date of the actual completion of the international search

18 MARCH 2013 (18.03.2013)

Date of mailing of the international search report

25 MARCH 2013 (25.03.2013)

Name and mailing address of the ISA/KR


 Korean Intellectual Property Office
 Government Complex-Daejeon, 189 Seonsa-ro, Daejeon 302-701,
 Republic of Korea

Facsimile No. 82-42-472-7140

Authorized officer

Telephone No.

INTERNATIONAL SEARCH REPORT
Information on patent family members

International application No.

PCT/KR2012/010461

Patent document cited in search report	Publication date	Patent family member	Publication date
JP 2003-113565 A	18.04.2003	JP 3790694 B2	28.06.2006
WO 91-02705 A1	07.03.1991	US 05371050 A US 6309994 B1	06.12.1994 30.10.2001
JP 2009-046374 A	05.03.2009	NONE	
JP 11-335183 A	07.12.1999	NONE	
JP 05-331297 A	14.12.1993	NONE	
KR 10-1996-0003793 B1	22.03.1996	JP 07-068178 A	14.03.1995

REFERENCES CITED IN THE DESCRIPTION

This list of references cited by the applicant is for the reader's convenience only. It does not form part of the European patent document. Even though great care has been taken in compiling the references, errors or omissions cannot be excluded and the EPO disclaims all liability in this regard.

Patent documents cited in the description

- KR 1020040086165 [0003]